

# Work Order ID 83666

April-23-12 10:18:26 AM

**\*83666\***

Page 1

Item ID: DSI 9519-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Bushing Installation

Start Date: 23/04/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 07/05/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/23 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
DSI 9519	B								
100	DOCUMENT CONTROL	0.00							
<b>*100*</b>									
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP DSI 9519-011 CHG 001								
110	Pick Kit	0.00							
<b>*110*</b>									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

DA 16 9-8 12/04/23

MLJ 12 9-24

2

12/09/21 JB

[8]

DA 16 9-8 12/04/25

72

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 83666

April-23-12 10:18:26 AM

**\*83666\***

Page 2

Item ID: DSI 9519-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Replacement Bushing Installation

Stop **\*NS2\***

Start Date: 23/04/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 07/05/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP DSI 9519-011								
	Location: _____								
	PPP Rev: <u>DMFT</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

*6/2/12 23 (2)*

*12/9/25*

*ME  
12-09-25*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

April-23-12 10:18:30 AM

Page 1

Work Order ID: 83666

\*83666\*

Parent Item: DSI 9519-011

\*DSI 9519-011\*

Parent Item Name: Replacement Bushing Installation

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-06-01 JLM VERIFIED BY:DD IPP  
REV:B 10.12.01 AS PER DWG REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4123-1		Manufactured	No			100	Each	0.0000					
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\*D4123-1\*  
Bushing

\*\* 8 16 ✓  
83665 JB 12/09/21 JB  
SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action -- Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# DART SERVICE INSTRUCTION

TO AMEND:

INSTALLATION INSTRUCTIONS D205-634 REV. F OR EARLIER,  
INSTALLATION INSTRUCTIONS D204-635 REV. F OR EARLIER,  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-634 REV. 3 OR EARLIER,  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D204-635 REV. 3 OR EARLIER

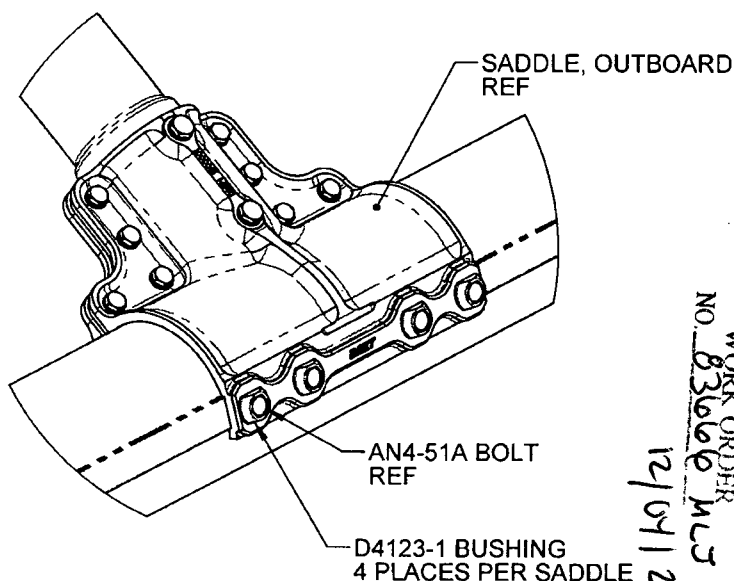
REF CANADIAN STC: SH96-88  
REF FAA STC: SR00563NY  
REF EASA STC: EASA.IM.R.S.01303

IT IS ACCEPTABLE TO REPLACE EXISTING D2570 BUSHINGS WITH D4123-1 BUSHINGS ON THE OUTBOARD SADDLES AS SHOWN IN FIGURE 1. ENSURE THE FLATS ON THE D4123-1 BUSHINGS RUN PARALLEL TO SKIDTUBE AS SHOWN IN FIGURE 1. TORQUE NUT ON AN4-51A BOLT TO 50-70 in-lb (5.7-7.9 N-m).

QTY	PART NUMBER	DESCRIPTION
X	DSI 9519-011	REPLACEMENT BUSHING KIT
8	D4123-1	BUSHING

**B** FURTHERMORE, IT IS ACCEPTABLE TO REMOVE THE D2594-1 PLUGS COMPLETE WITH D2594-3 O-RINGS AND SEAL THE HOLES WITH SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT.

THERE IS NEGLIGIBLE EFFECT ON WEIGHT AND BALANCE WITH THIS CHANGE.



**FIGURE 1. D4123-1 BUSHING INSTALLATION**

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: *D. Shepherd*  
D. SHEPHERD (DE # 02)

DATE: 10.07.20  
CERT. NO.: SH96-88  
ISSUE NO.: 3

B	ADD NOTE RE: D2594-1 PLUG REMOVAL	RF	10.07.20
A	NEW ISSUE	RF	10.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9519	SHEET 1 OF 1
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	REPLACEMENT BUSHING KIT	NTS
DATE	10.07.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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TO AMEND:

INSTALLATION INSTRUCTIONS D205-634 REV. F OR EARLIER,  
INSTALLATION INSTRUCTIONS D204-635 REV. F OR EARLIER,  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-634 REV. 3 OR EARLIER,  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D204-635 REV. 3 OR EARLIER

REF CANADIAN STC: SH96-88  
REF FAA STC: SR00563NY  
REF EASA STC: EASA.IM.R.S.01303

**REFERENCE ONLY**

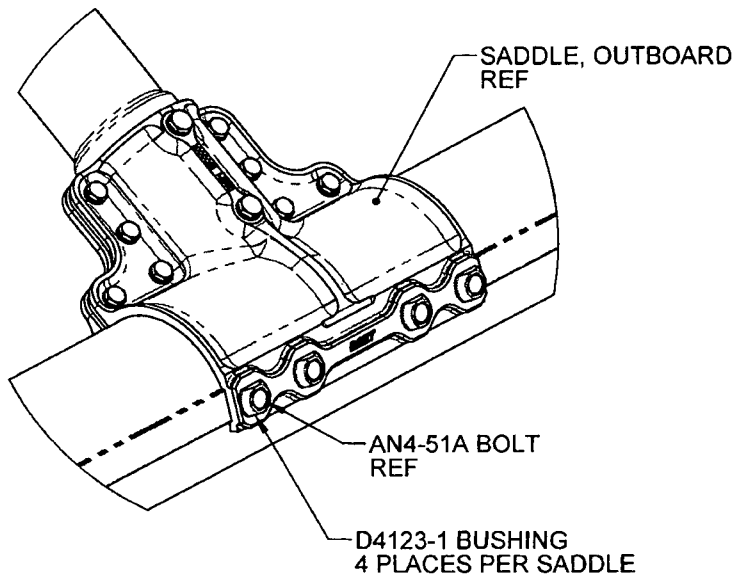
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QTY	PART NUMBER	DESCRIPTION
X	DSI 9519-011	REPLACEMENT BUSHING KIT
8	D4123-1	BUSHING



FURTHERMORE, IT IS ACCEPTABLE TO REMOVE THE D2594-1 PLUGS COMPLETE WITH D2594-3 O-RINGS AND SEAL THE HOLES WITH SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT.

THERE IS NEGLIGIBLE EFFECT ON WEIGHT AND BALANCE WITH THIS CHANGE.



**FIGURE 1. D4123-1 BUSHING INSTALLATION**

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: *D. Shepherd*  
D. SHEPHERD (DE # 02)

DATE: 10.07.20  
CERT. NO.: SH96-88  
ISSUE NO.: 3

B	ADD NOTE RE: D2594-1 PLUG REMOVAL	RF	10.07.20
A	NEW ISSUE	RF	10.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9519	SHEET 1 OF 1
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	REPLACEMENT BUSHING KIT	NTS
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